

## Versa Laser glass cutting with a 4<sup>th</sup> Axis

28.9.06

1. Take the cone off the laser, this is only used to stop flammable material setting on fire.
2. Measure and record the largest diameter of the glass
3. Place the glass in the 4<sup>th</sup> axis
4. In the FOCUS tab using the mouse jog the Laser axes so that they are in line with the top and bottom of the glass

E.G. Top – 560 mm

Bottom – 415 mm ( Glass length = 145 mm long)

5. Run Techsoft and select LINE from the menu, draw 2 vertical line at 425 mm and 560 mm these are construction lines
6. Select text and write your text in the screen, you can select different font styles and sizes.
7. Rotate the text through 90 degrees clockwise with the movement icons when the text has been selected
8. With the central movement icon, pick up the text and move it to the top inside right on the furthest construction line at 560 mm, in this case (You can position the text any where on the top between the two construction lines, note if the glass is tapered the further away from the largest dia will give poorer quality and finish)
9. Now delete the construction lines
10. Select FILE then PRINT from the drop down box and VL300 then OK
11. The Versa laser software should now appear
12. Select GLASS/CERAMIC
13. Select GLASS-MARKING (Material code is 1502)

14. Select FI XTURE TYPE – ROTARY
15. Change the DI AMETER to the largest of the glass e.g. 89 mm
16. Close TECHSOFT down and open the Versa Laser software
17. The text for the glass appears equally spaced around a light green centre line
18. Then run the program